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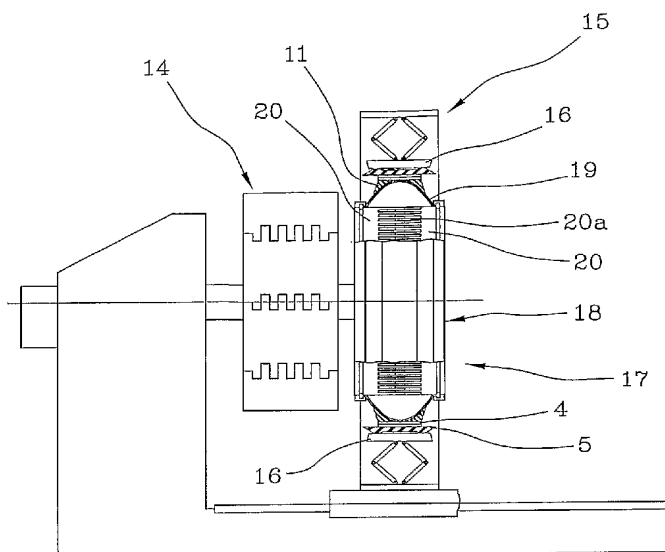
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(54) Title: METHOD AND APPARATUS FOR MANUFACTURING TYRES FOR VEHICLE WHEELS



(57) Abstract: In the field of tyre building, underbelt inserts (11) are applied to an expandable support (18) associated with an auxiliary drum (14) on which the belt structure is made, simultaneously with manufacture of a carcass structure (3) on a primary drum (13). Following expansion of the expandable support (18), the underbelt inserts (11) are applied to the belt structure (4) that can be directly made on the support (18) itself in an expanded condition. The belt structure (4) together with the underbelt inserts (11) and a tread band (5) are then transferred onto the carcass structure (3) formed on the primary drum (13), to complete building of the tyre (2) following shaping of the carcass (3) into a toroidal conformation.

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